

Date: Monday, 7/16/2007 2:44:10 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR DOUBLER
Job Number : 33552	
Estimate Number : 12942	
P.O. Number : <i>N/A</i>	Part Number : D3594044
This Issue : 7/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3594 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33524	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/30/2007 Qty: 16 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.07.17	
Comment : Est Rev : A New Issue 07-01-22 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.5355 sf(s)/Unit Total : 8.5680 sf(s)

6061-T6 .080 Sheet

Batch: *M 104921**IB 07-07-26*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: *A*Prog Rev: *A**IB 07-07-26**(16)+3*

2-Deburr if necessary

*ml 07/07/30 (x19)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*IB 07-07-26*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*En 07/07/30**(x19) (cont)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

*ml 07/07/30**x19*

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Drawing Name: DOOR DOUBLER

Job Number: 33552

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/30 (18)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HD 07-07-30 (19)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/08/01 (X19)

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Anchor nuts

BATCH: 104214 -

CB

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

BATCH: 1021

CB 7/8/01 (20)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

ml 07/08/01 (X19)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/02 (X19) counter

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

CB 07/08/02 (19)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 33552

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(19)

Comment: FINAL INSPECTION/W/O RELEASE

2/02/08/03

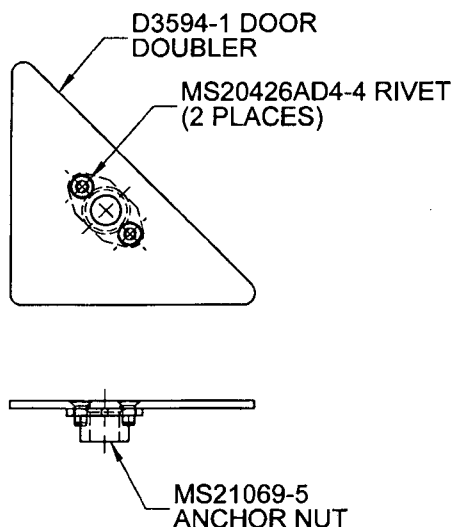
Job Completion



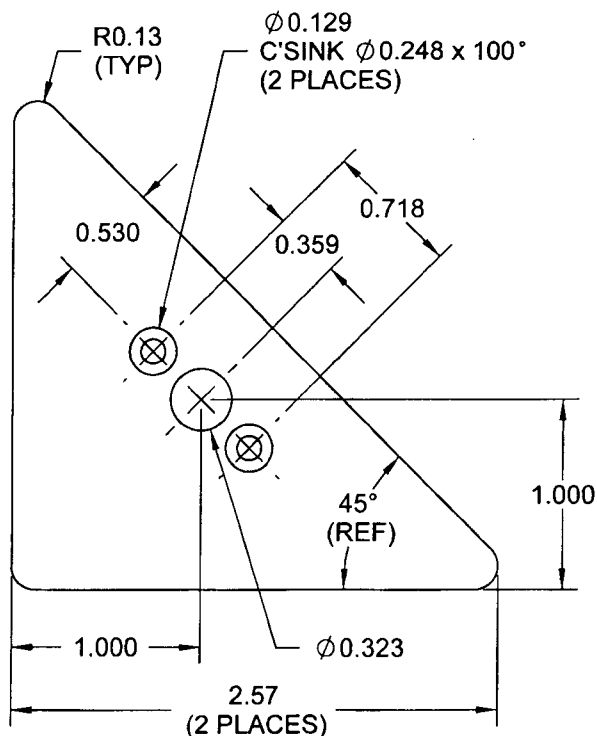
Jul/07-08-02

**DART****RELEASED**  
07.07.11  
Per [signature]

DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [signature]	APPROVED [signature]	DRAWING NO. <b>D3594</b>	REV. A SHEET 1 OF 3
DATE <b>07.04.13</b>		TITLE <b>DOUBLER</b>	SCALE 1:1
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**D3594-041 DOOR DOUBLER ASSEMBLY**   
SCALE 1 : 2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET

**D3594-1 DOOR DOUBLER** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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NO **33552**

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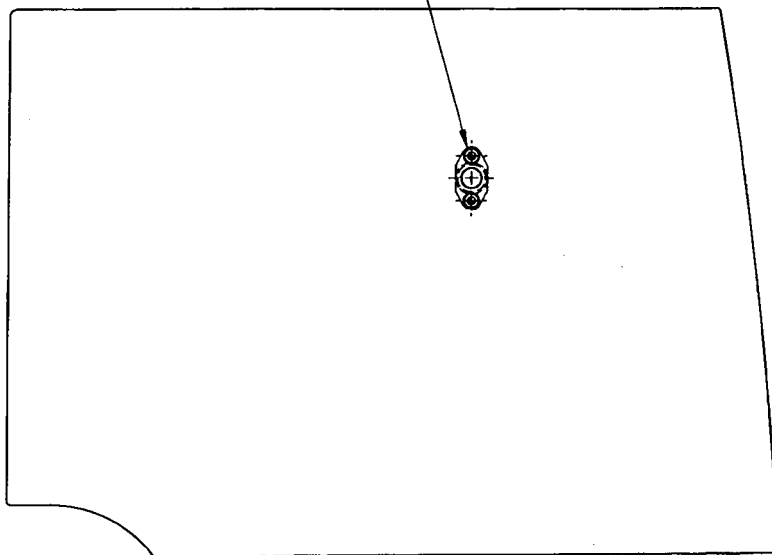


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3594</b>	REV. A SHEET 2 OF 3
DATE <b>07.04.13</b>		TITLE <b>FLOOR DOUBLER ASSEMBLY</b> SCALE 1:3	

**RELEASED**  
07.07.11

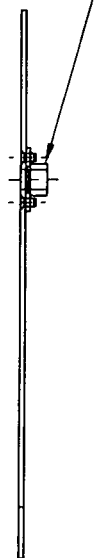
Per ECW #1024

MS20426AD4-4 RIVET  
(2 PLACES)



D3594-3 FLOOR DOUBLER (D3594-043)  
D3594-4 FLOOR DOUBLER (D3594-044)

MS21069-5  
ANCHOR NUT



**D3594-043 FLOOR DOUBLER ASSEMBLY**  
**(D3594-044 OPPOSITE)**

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

**NOTES:**

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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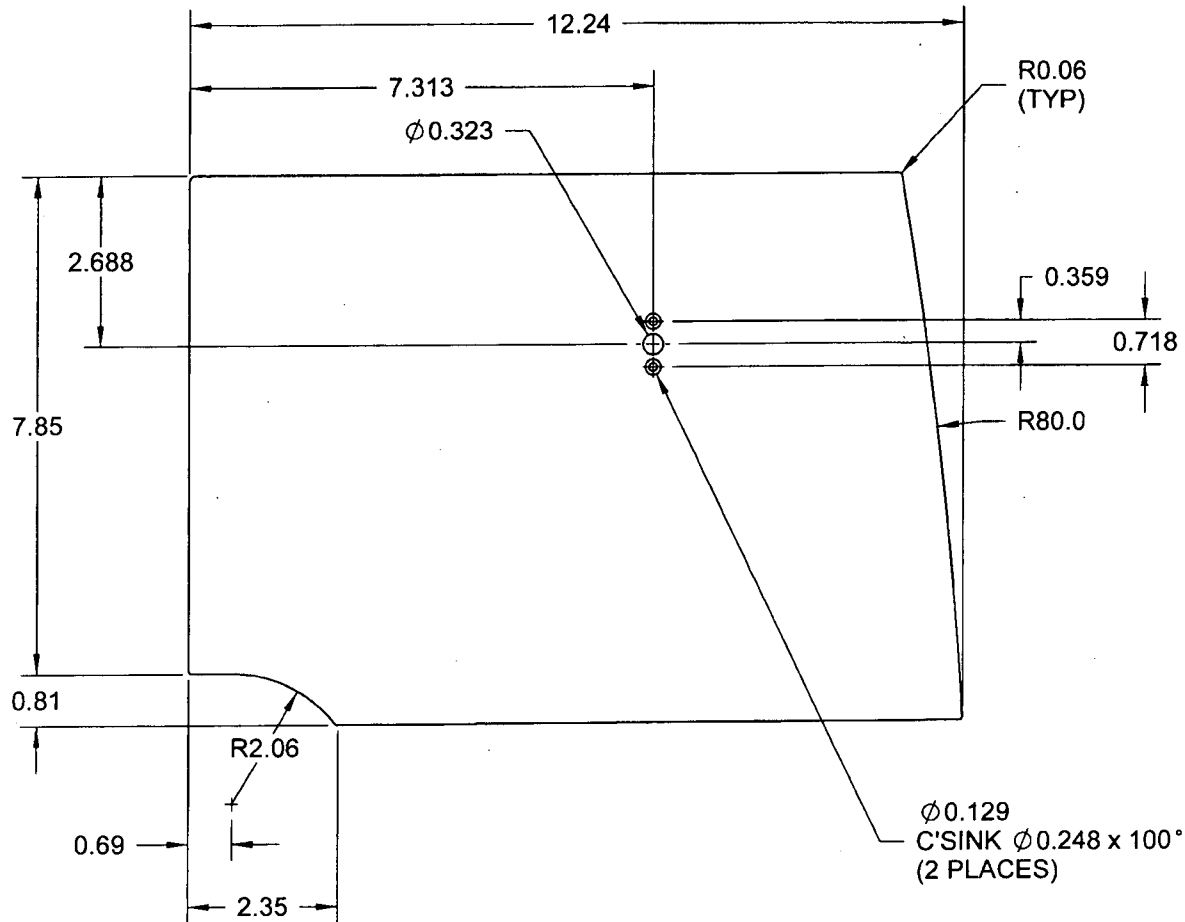
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3594</b>	REV. A SHEET 3 OF 3
DATE <b>07.04.13</b>		TITLE <b>DOUBLER</b> SCALE 1:3	

**RELEASED**  
07.07.11 *B*  
PER 6041001



**D3594-3 FLOOR DOUBLER**  
**(D3594-4 OPPOSITE)**

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